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7344
Dec 7

RBE105-31781W2-1
Job Sheet 185443



Part No: RBE105-31781W2-1

Job Qty: 1 ea

Part Name: Base Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31781W2 Rev.0 IPP Rev. A 18.10.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/9/18	0.00	0.00	Start Up Small Fab-2		MCC
110	Small Fab	1 pcs		11/9/18	0.00	1.00	Small Fab-3		MCC DAS
120	QC	1 pcs		11/9/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/9/18	0.00	0.00	Packaging3-1		9-88
140	QC21-SA	1 Ea		11/9/18	0.00	0.00	QC21		21

Part Op
Descriptions: 110 - 1-Assemble as per DWG. See note.

9-88 JAN 16 2019

GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-31781W2-11	030.01 Pin	1 Ea (1 ea)	90-Start up Operation	5125697
RBE105-31781W2-15	040.01 Pin	1 Ea (1 ea)	90-Start up Operation	5125452
RBE105-31781W2-7	020.01 Pin	1 Ea (1 ea)	90-Start up Operation	5125889
RBE105-31781W2-13	040.01 Base	1 Ea (1 ea)	110-Small Fab	5137418
RBE105-31781W2-3	Base	1 Ea (1 ea)	110-Small Fab	5123012
RBE105-31781W2-5	020.01 Base	1 Ea (1 ea)	110-Small Fab	5137436
RBE105-31781W2-9	030.01 Base	1 Ea (1 ea)	110-Small Fab	5138038

1412
138
1412

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE105-31781W2-11	1	0	0
	RBE105-31781W2-15	1	0	0
	RBE105-31781W2-7	1	0	0
	RBE105-31781W2-13	1	0	0
110-Small Fab	RBE105-31781W2-3	1	0	0
	RBE105-31781W2-5	1	0	0
	RBE105-31781W2-9	1	0	0

Part Specifications

Specifications could not be found.

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____

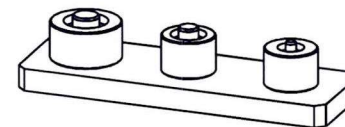
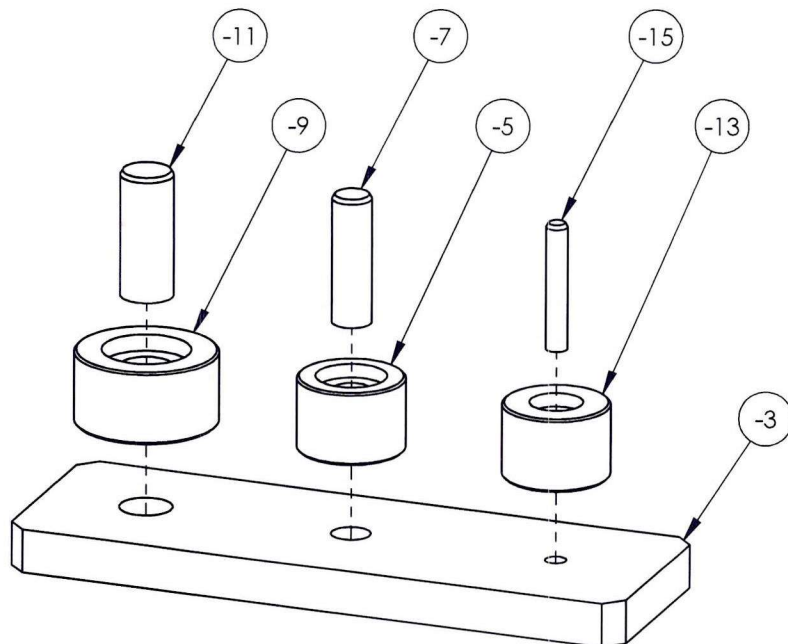
Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



SHOP COPY
 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 18743ms
 18-10-26

NOTE:
PRESS ALL PINS IN SO THAT NON-CHAMFERD END IS
FLUSH WITH BOTTOM OF -3.

-1

BASE ASSEMBLY

DART AEROSPACE	
TITLE MILLING TOOL	
DWG NO. RBE105-31781W2-1	REV ?
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	USED ON MODEL
APPROVED:	EC145, H145
SCALE 1:2	DATE 04/08/2017
SHEET 2 OF 12	



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www.dartaerospace.com

Container No: S145010



Part: RBE105-31781W2-1

Job No: 185443

Serial No/Batch: S145010

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 01/15/19